Work Order ID 85188

Page 1 June-04-12 1:29:41 PM Item ID: D350-636-101 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Toe Step, LH/RH **Start Date:** 04/06/2012 Start Qty: 6.00 **Cust Item ID:** Required Date: 18/06/2012 Req'd Oty: 6.00 **Customer:** Reference: Run Start Process Plan: \_Mして Date: 1000 04 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3487 Rev A 100 0.00 DOCUMENT CONTROL MLJ 12107/19 \*100\* DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPPD350-636-101 CHG001 -6061.100 110 0.00 \*110\* Jm 12-6-19 Waterjet 0.00 Memo

FLOW CNC Waterjet

1-Cut as per Dwg \*\*\* D3487-1\*\*\*

Dwg Rev: Prog Rev:

2-Deburr if necessary

Dart Aerospace L
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W/O:			WO	RK ORDER CH	ANGES		. , ,	· · · · · · · · · · · · · · · · · · ·		
DATE	STÉP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			141							
Part No	:	PAR #:	Fault Cateo	jory:	NC	R: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	n:	QA	: N/C CI	osed:		Date: _	<u>.</u>
NCR:		V	VORK ORDE	R NON-CONFO	RMANCE	(NCR	1)			
DATE	STEP	Description of NC Section A	NC Corrective Action De			Section B Sign &			Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date		on C		
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Work Order ID 85188  June-04-12 1:29:41 PM			*85188*					•		A- <del></del>	Page 2		
Item ID: Revision ID: Item Name:	D350-636-10			Accept	*N900	040°	100	)*	Setup	Start Stop		S1* S2*	13 = -
	04/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II	D:					TN.	<b>7</b>	
Approvals:	Process Pla	n:				ite:			Run	Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	<del></del>
*120 *120 *120 *QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				6		<b></b> .		Jm_	2-6-
130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	0.00 Taluel	(૧		(	46)	L				
150 *150* Brake NC		NC BRAKE		0.00				6				S 12	p . 67 1

Brake NC

Form as per Dwg D3487

W/O:			W	ORK ORDER CHANGI	IANGES						
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	_ Fault Car	tegory:	NCR: Yes	No DQA: _	Date: _				
	R	esolution:	_ Disposit	ion:	QA: N/C Cld	sed:	Date: _				
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR	)					
DATE STEP		Description of NC		Corrective Action Section		Verification	n Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Item ID: Revision ID: Item Name:	D350-636-10			Accept	*N900	040	1100	ገ*	Setup Star	17	S1*
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item   Customer:	ID:				IN	.J/
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:			Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comp	oleteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* HandFinish Hand Finishing		Chemical Conversion C	Coat per QSI005 4.1	0.00				6		M 12	-7-19
*180 *180* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1  Memo ATTN: PA		0.00	:	7 ~		6×			M2/07/
1218	4	( <b>4</b> °)	Sta. Ten	TTIME	1,92 320 1e/10	50 5F 200					÷.

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W/O:			W	ORK ORDER CHA	CHANGES						
DATE	STEP	PROC	EDURE CH	ANGE	in the	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Cat	egory:	NCI	R: Yes	No <b>DQ</b>	<b>A</b> :	Date:		
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NCR:		W	ORK ORI	DER NON-CONFOR	RMANCE	(NCR	)		*	*	
DATE	DATE STEP Description of NC Section A			Initial Action Description Chief Eng Chief Eng				cation tion C	Approval Chief Eng	Approval QC inspector	
		T as	Onler Eng	Cnier Eng		Date					
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Work Order ID 85188  June-04-12 1:29:41 PM				Page 4					
Revision ID: Item Name:	D350-636-10 Toe Step, LH/		*6*	Accept	*N900040100	<b>)</b> *	Setup	Start Stop	*NS1* *NS2*
Required Date: Reference:	: 18/06/2012 Req'd Qty: 6.00		*6*		Customer:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:			Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID  190  *100* HandFinish Hand Finishing	)	Operation Description Wing Walk as per dwg QS Memo	S1005 4.4 Batch 11/12	Set Up/ Run Hours USO § 5.00 0.00	Tool ID Tool # Plan Code	Accep Qty	t Reje Qty	ect R	Reject Insp. Jumber Stamp  U N 04 F
* <b>200</b> * <b>200*</b> QC Quality Control		QC3- Inspect Part Finish  Memo		0.00		6	ф	, 	Bl 12719

210

\*210\* Packaging

Packaging

Packaging

0.00

0.00

Identify and pack for shipping as per PPP D350-636-101 Location: 57 47 2
PPP Rev: \_\_\_\_\_

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector					
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No Do	QA:	Date: _	<del></del>					
	R	esolution:	Dispositi	on:	_ QA: N/C	Closed: _		Date: _						
NCR:		V	VORK ORI	DER NON-CONFORMA	ANCE (NO	CR)								
DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B Sigi		fication	Approval	Approval					
		Section A	Chief Eng	Chief Eng	Da Da		ction C	Chief Eng	QC Inspector					
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Work Ord  June-04-12 1:	der ID 85188 29:41 PM		*85	188*		Page
Item ID: Revision ID: Item Name:	D350-636-101  Toe Step, LH/RH		Accept	*N900040100°	Setup Star	1/2/1
Start Date: Required Date Reference:	04/06/2012 Start Qty: 6.0 e: 18/06/2012 Req'd Qty: 6.0	` '		Cust Item ID: Customer:		, IV.37
Approvals:	Process Plan:QC:	Date:	Tooling: SPC (Y/N):	Date:	Run Star	"NR1"
Sequence ID/ Work Center	Operation ID Description		Set Up/ Run Hours		Accept Reject Oty Oty	Reject Insp.

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

230

\*230\*

Quality Control

Insp. Stamp

Page 5

				ORK ORDER CHANG					
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			4						:
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Part No:		PAR #:	_ Fault Cate	egory:	_ NCR: Yes	No DO	QA:	Date: _	
	Res	solution:	_ Dispositi	on:	_ QA: N/C (	Closed: _		Date: _	
NCR:		W	ORK ORE	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		on B	Verit	ication	Approval Chief Eng	Approval	
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date			ction C	QC Inspector
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#### **Picklist Print**

June-04-12 1:29:45 PM

Work Order ID: 85188

D350-636-101

\*85188\*

\*D350-636-101\*

Parent Item Name: Toe Step, LH/RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Parent Item:

IPP Rev:A New Issue 06-03-03 JLM

11.03.15 now made in house DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			110	sf	69.7000	0.7942	(5.016)			
*M6061T6	SS 100*								**	9.010			T

### \*M6061T6S 100\*

6061-T6 .100 Sheet

Location	Loc Qty	Loc Code	
MAT021	69.7		_
102201	1		
118072	5.7		
118523	63		11852

Jn 12-6-19

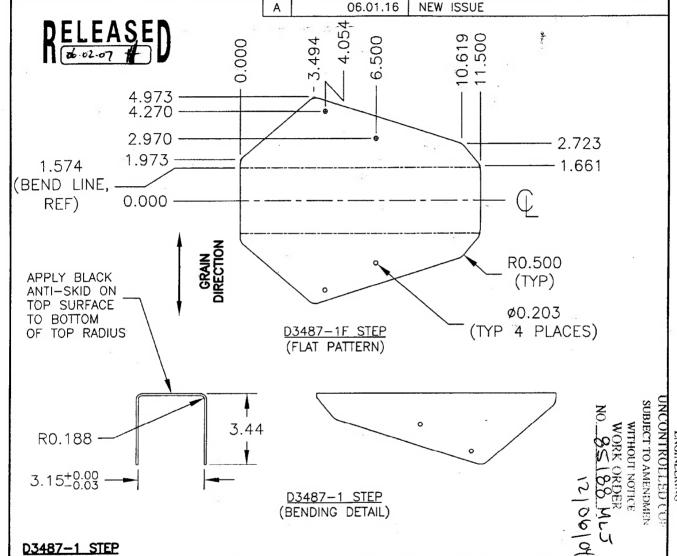
Page 1

Dart Aerospa	ice	Ltd
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W/O:			W	ORK ORDER CHANG	ES					<del></del>
DATE	STEP	PRO	CEDURE CHA	NGE	1	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			A							
									*	
					4					
				4.						
Part No		PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo <b>DQ</b>	A:	_ Date: _	
			Disposition: Q						Date:	
NCR:	*		WORK ORD	ER NON-CONFORMA	NCE (	NCR)	·····			
DATE	STEP	Description of NC	Description of NC Corrective Action		Section B		Verific	Verification App		Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	;	Sign & Date		on C	Chief Eng	QC Inspector
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DESIGN PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK,		NC.
CHECKED	APPROVED 41	DRAWING NO.			REV. A
#	#	D3487		SHEET	1 OF 1
DATE	.1	TITLE			SCALE
06.01.16		STEP			1:4



D3487-1 STEP

MATERIAL:

ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK

(REF DART MATERIAL SPEC M6061T6S.100)

FINISH: 2)

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4

ALL DIMENSIONS ARE IN INCHES 3)

- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- PART IS SYMMETRICAL ABOUT CENTERLINE 5)
- BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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W/O:			WO	RK ORDER CHANGES	<u>S</u>			<del></del>
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	) <b>:</b>	PAR #:	Fault Cated	gory:	NCR: Yes	No DQA:	Date: _	
	Re	solution:	Disposition	n:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCF	R)		<del></del>
5.475		Description of NC	Corrective Action Section B			Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspect
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DART AEROSPACE LTD	Work Order:	85/88	
Description: Step	Part Number:	D3487-1	
Inspection Dwg: D3487 Rev: A		Page 1 of 1	

#### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	0.204"	~		1/	mmol
3.494	+/-0.010	3.495"	_		V	N N
4.054	+/-0.010	4,660"	V		V	n
6.500	+/-0.010	6.495"	~		W	in
10.619	+/-0.010	10.619"	~		V .	Buginlas
11.500	+/-0.010	(1.500"			V	Ralingoz
1.973	+/-0.010	1,973"	~		ν	Mmoi
2.970	+/-0.010	2, 973"	1		V	3,7
4.270	+/-0.010	4.273	U U		V	Productor
4.973	+/-0.010	4. 9.73"	~		V	71
0.100	+/-0.010	0.097	\		V	mmer
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Meas	ured by:	JM	Audited by:	Preliminary Approval:	
	Date:	12-6-19.	Date: (7/06/9	Date:	
Rev	Date	Change		 Revised by	Approved
Δ	11 03 24	New Issue		 VI CUX	